

Date: Tuesday, 21/10/2008 2:45:26 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: 206 EXTRUSION BENDING		
Job Number	: 42769			Part Number	: D2620		
Estimate Number	: 10311			Drawing Number	: D2620 REV B		
P.O. Number	:			Project Number	: N/A		
This Issue	21/10/2008	S.O. No.	:	Drawing Revision	: B		
Prsht Rev.	: NC			Material	:		
First Issue	11	Type	SKIDTUBES	Due Date	: 10/11/2008		
Previous Run	: 41820			Qty:	12	Um:	Each
Written By	:			16 DP 8-11-3			
Checked & Approved By	: JUL 08 10.21						
Comment	: Est. D 02.07.26 Change Dwg to rev.B; Updated Location RF						

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :		
1.0	D26001160	Extrusion Round 3" 206		
Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s) Extrusion Round 3" 206 Pick; Qty Part Number Description Batch 1 D2600-1 Extrusion Round 3"206 34715 RT 08-11-03				
2.0:	SKIDTUBES 1	SKIDTUBESS RESOURCE 1		
Comment: LANDING GEAR RESOURCE 1 1-Bend extrusion as per Dwg D2620 using CNC Bending Machine program 206.A and Folio Ft008 2- Cut Fwd end of tube as per Dwg D2620 RT 08-11-04				
3.0	QC5	INSPECT WORK TO CURRENT STEP		
Comment: INSPECT WORK TO CURRENT STEP				
4.0	PACKAGING 1	PACKAGING RESOURCE #1		
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: Skid tubes RT 08-11-04				
5.0	QC21	FINAL INSPECTION/W/O RELEASE		
Comment: FINAL INSPECTION/W/O RELEASE				
Job Completion				

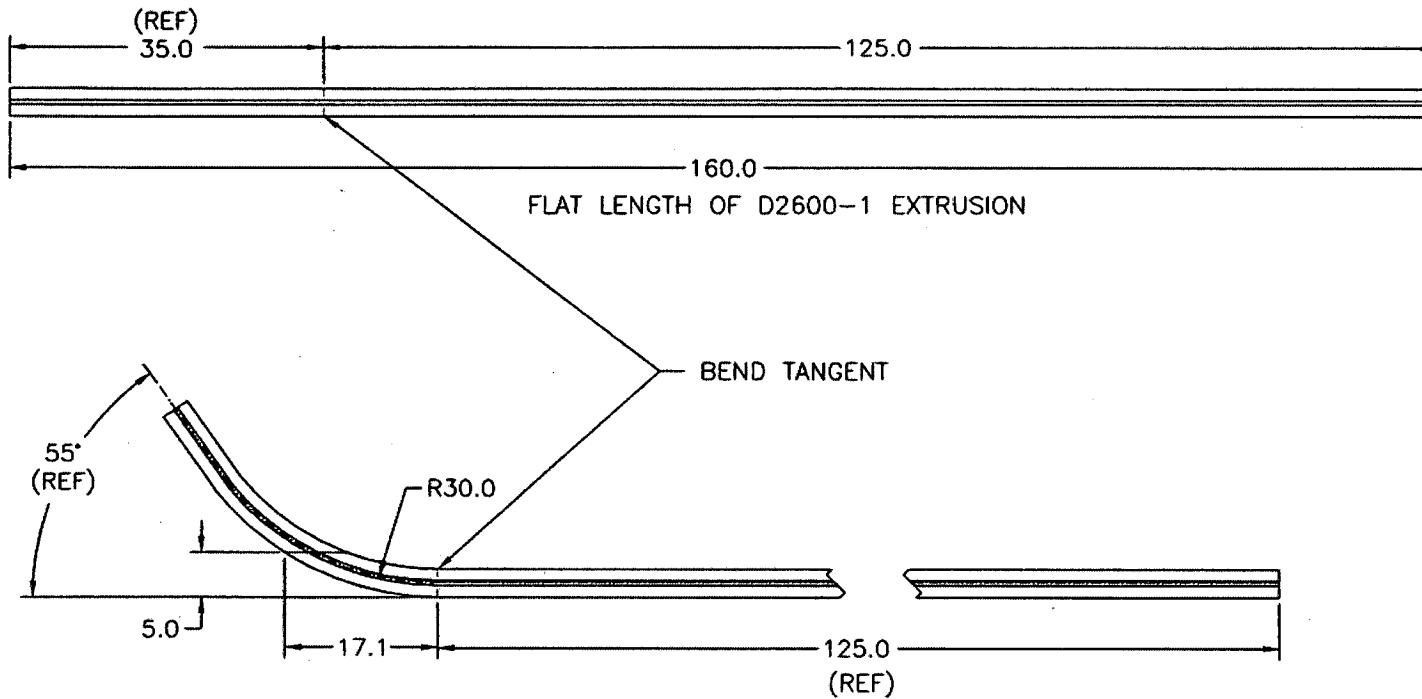
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

SPECIFICATION CONTROL DRAWING
206 SKIDTUBE BENDING



DAMAGE TOLERANCE

1. THERE SHOULD BE NO VISIBLE WRINKLES BELOW 5.0 AFTER BENDING.
2. GOUGES UP TO 0.020 DEEP ARE ACCEPTABLE IN BENT PORTION OF THE TUBE.
NO GOUGES ARE ACCEPTABLE IN THE FLAT PORTION OF THE TUBE.
DEEPER GOUGES ARE ACCEPTABLE IN THE PORTION OF THE TUBE ABOVE 5.0.
3. TUBE WIDTH SHOULD BE 3.20 ± 0.200 IN THE BEND.
TUBE WIDTH SHOULD BE 3.200 ± 0.010 IN THE FLAT PORTION OF THE TUBE.
4. TUBE HEIGHT SHOULD BE 3.15 ± 0.200 IN THE BEND.
TUBE HEIGHT SHOULD BE 3.150 ± 0.010 IN THE FLAT PORTION OF THE TUBE.

NOTE: ALL DIMENSIONS ARE IN INCHES

RELEASED
 49-04-15 DS

DESIGNER	DRAWN BY	DART AEROSPACE USA, INC.
REVIEWED	APPROVED	FAIRCHILD INTERNATIONAL AIRPORT, WA
<i>W</i>	<i>KE</i>	DRAWING NO. REV. B
DATE	99.09.10	TITLE
		206 SKIDTUBE BENDING CONTROL
A	97.11.07	SCALE
B	97.09.10	1:20
		SHEET 1 OF 1
		WITHOUT CHARGE